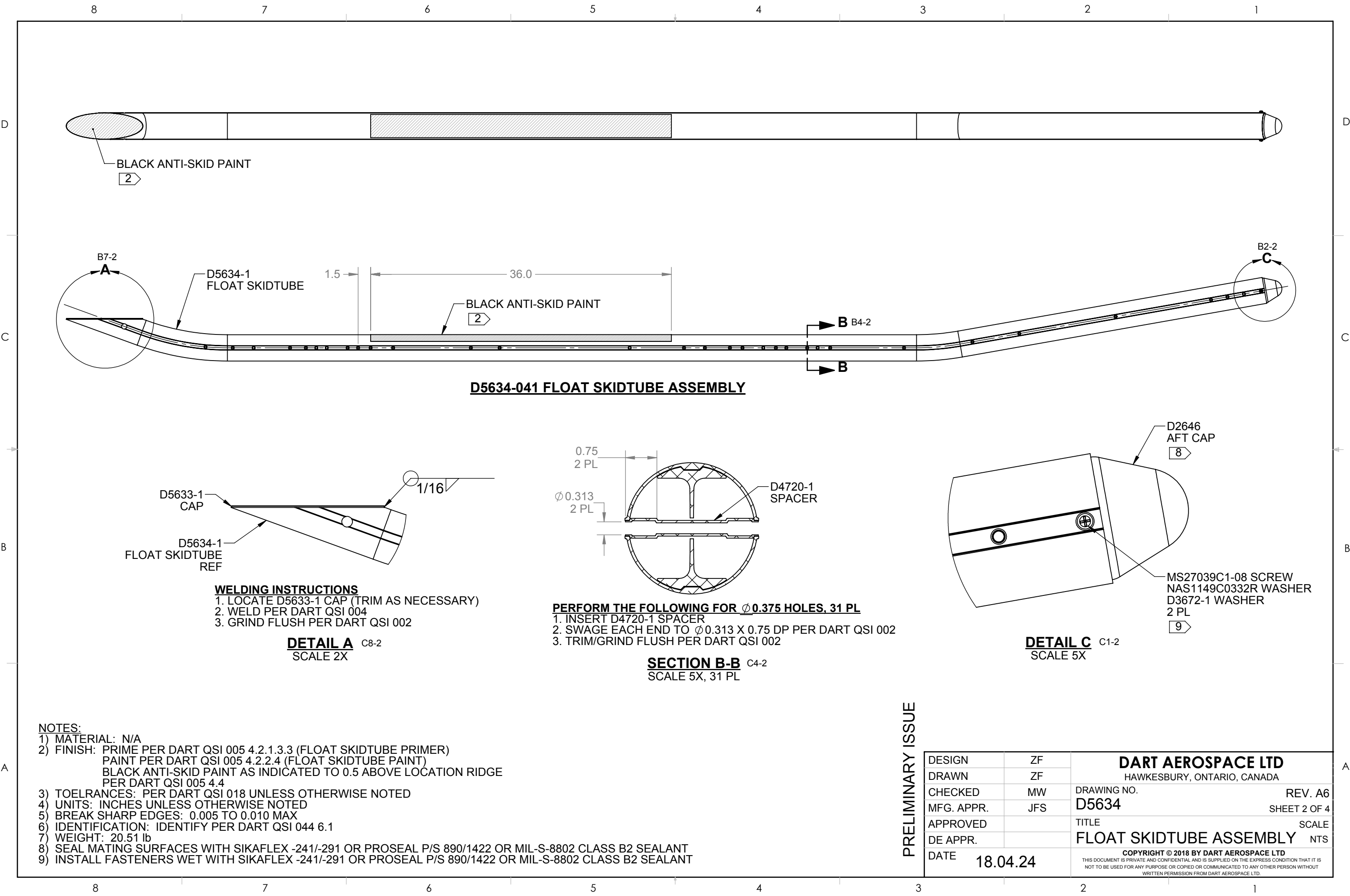
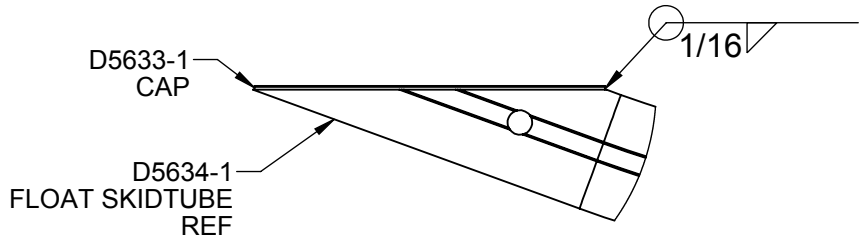


QTY -041	PART NUMBER	DESCRIPTION
X	D5634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2646	AFT CAP
2	D3672-1	PHENOLIC WASHER
31	D4720-1	SPACER
1	D5633-1	CAP
1	D5634-1	FLOAT SKIDTUBE
1	D5636-041	FLOAT WEB
2	MS27039C1-08	SCREW, PAN-HEAD
2	NAS1149C0332R	WASHER

A	NEW ISSUE		ZF	18.04.24
REV.	DESCRIPTION		BY	DATE
DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	ZF			
CHECKED	MW	DRAWING NO. D5634 REV. A6 SHEET 1 OF 4		
MFG. APPR.	JFS			
APPROVED		TITLE FLOAT SKIDTUBE ASSEMBLY SCALE NTS		
DE APPR.				
DATE	18.04.24	COPYRIGHT © 2018 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

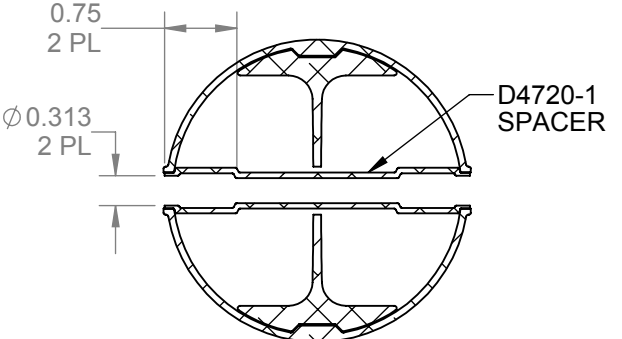


D5634-041 FLOAT SKIDTUBE ASSEMBLY



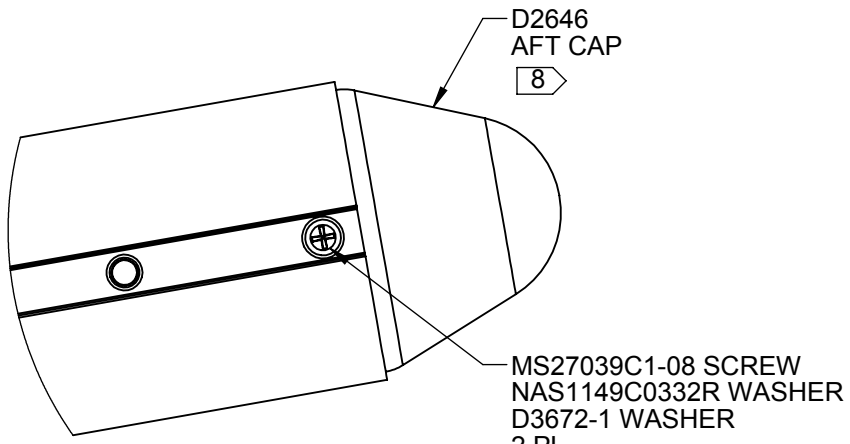
WELDING INSTRUCTIONS
1. LOCATE D5633-1 CAP (TRIM AS NECESSARY)
2. WELD PER DART QSI 004
3. GRIND FLUSH PER DART QSI 002

DETAIL A C8-2
SCALE 2X



PERFORM THE FOLLOWING FOR Ø0.375 HOLES, 31 PL
1. INSERT D4720-1 SPACER
2. SWAGE EACH END TO Ø0.313 X 0.75 DP PER DART QSI 002
3. TRIM/GRIND FLUSH PER DART QSI 002

SECTION B-B C4-2
SCALE 5X, 31 PL

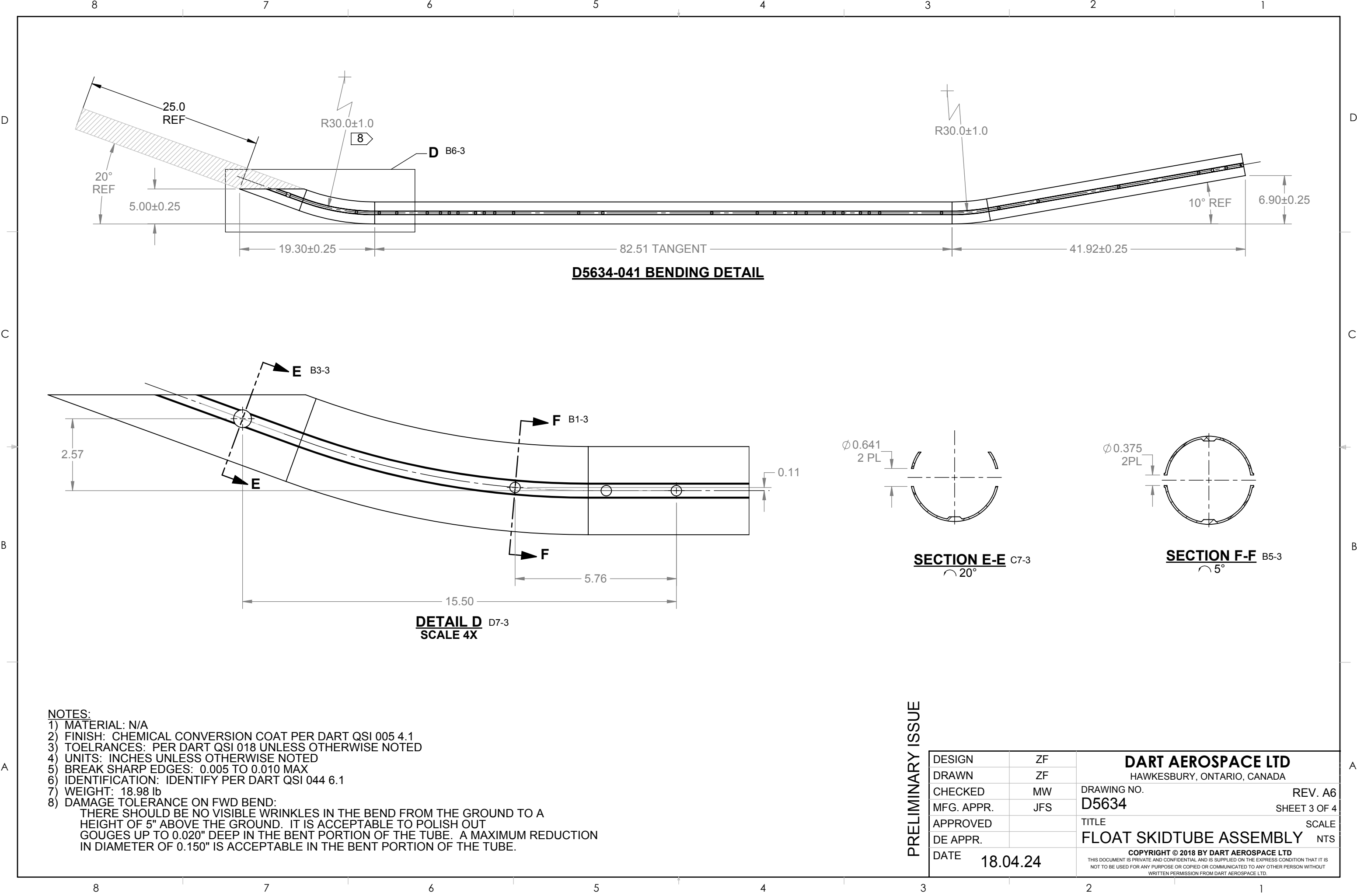


DETAIL C C1-2
SCALE 5X

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE
PER DART QSI 005 4.4
 - 3) TOELRANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 20.51 lb
 - 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890/1422 OR MIL-S-8802 CLASS B2 SEALANT

PRELIMINARY ISSUE

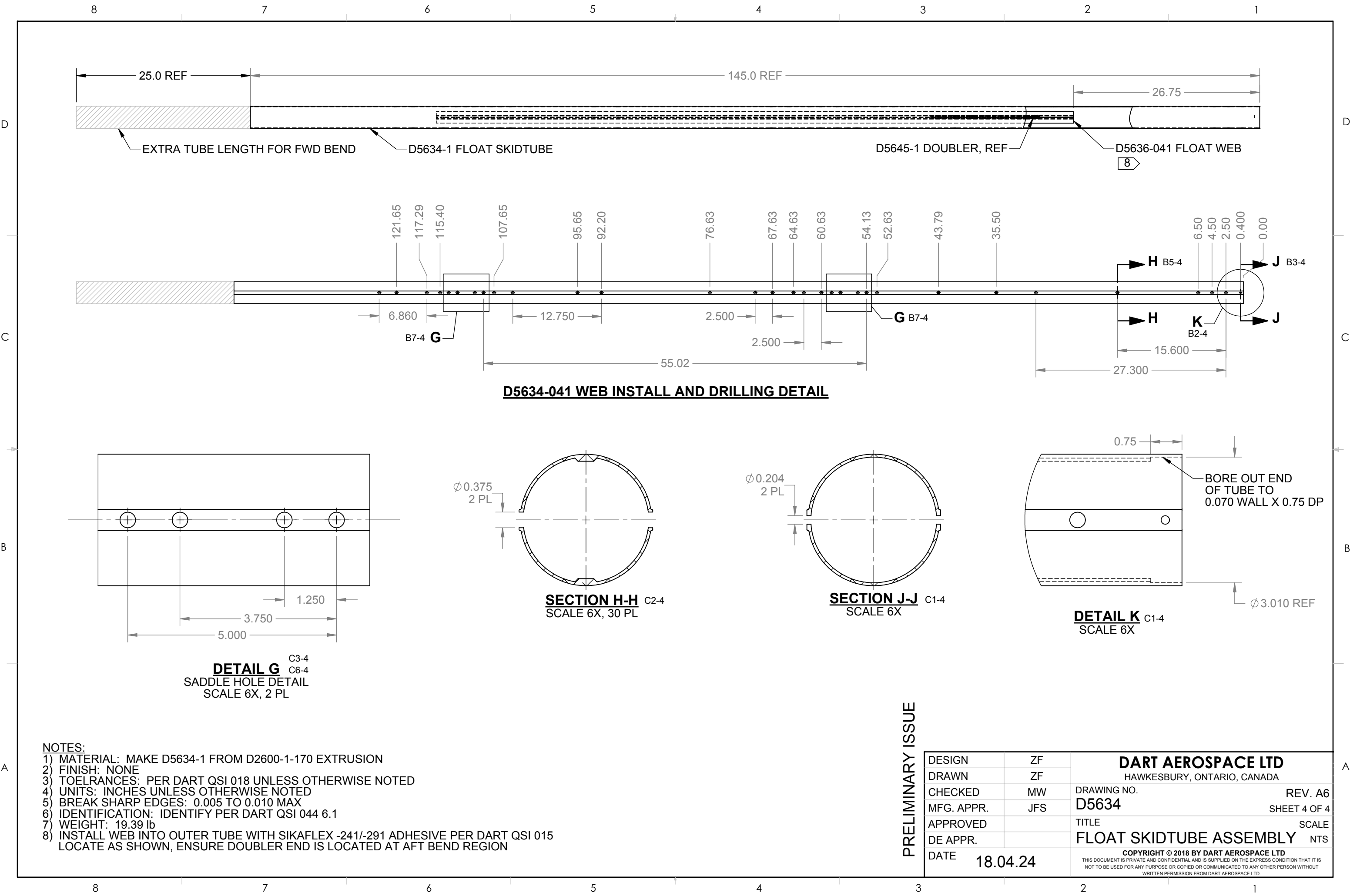
DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D5634	REV. A6 SHEET 2 OF 4
MFG. APPR.	JFS	TITLE FLOAT SKIDTUBE ASSEMBLY	
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2018 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	18.04.24		



NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: 18.98 lb
8) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A6
MFG. APPR.	JFS	D5634	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		FLOAT SKIDTUBE ASSEMBLY	NTS
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D5634-041 WEB INSTALL AND DRILLING DETAIL

DETAIL G C3-4
C6-4
SADDLE HOLE DETAIL
SCALE 6X, 2 PL

SECTION H-H C2-4
SCALE 6X, 30 PL

SECTION J-J C1-4
SCALE 6X

DETAIL K C1-4
SCALE 6X

- NOTES:
- 1) MATERIAL: MAKE D5634-1 FROM D2600-1-170 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOELRANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 19.39 lb
 - 8) INSTALL WEB INTO OUTER TUBE WITH SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015 LOCATE AS SHOWN, ENSURE DOUBLER END IS LOCATED AT AFT BEND REGION

PRELIMINARY ISSUE

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D5634	REV. A6 SHEET 4 OF 4
MFG. APPR.	JFS	TITLE FLOAT SKIDTUBE ASSEMBLY	
APPROVED		SCALE NTS	
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DATE	18.04.24		